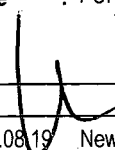
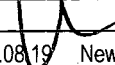


Date: Monday, 25/02/2008 11:43:55 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE BILLET (6061)
<b>Job Number</b> : 37600	
<b>Estimate Number</b> : 11988	
<b>P.O. Number</b> :	<b>Part Number</b> : D6102010
<b>This Issue</b> : 25/02/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D6102 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 26/02/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est. A 04.08.19 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** Issue P/O: ~~585~~ 5788

a) Description: Aluminum Billet

b) 7.950" x 8.250" x 2.500" thick

c) Tolerance on all dimensions is +0.06/0.00

d) Grain direction along 7.950" length

e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)

Material release certificate is required

C 208/02/25

(10)

2.0

D6102010P

6061-T6 8.25x7.95x2.5

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

6061-T6 8.25x7.95x2.5

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

PO 8/3/3

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Check certification to Dwg D6102 for compliance

Mk 08/03/07

(10)

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Mk 08/03/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/02/2008 11:43:55 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 37600

Part Number: D6102010

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/07

Job Completion



mi 2008/3/07

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

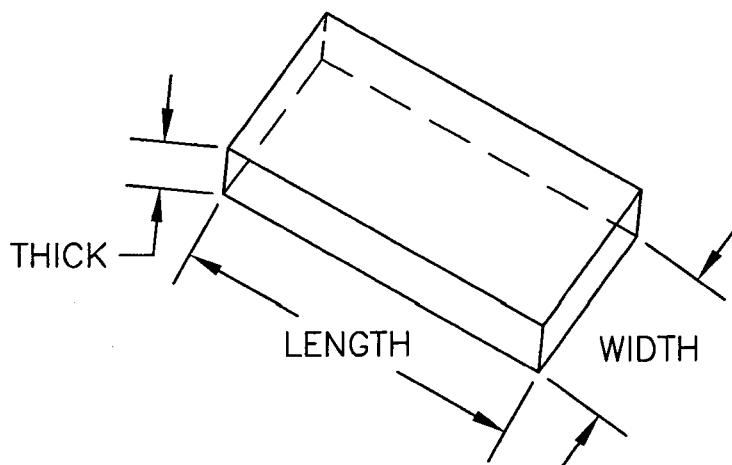
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

## SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# MAGNA

INDUSTRIAL

MAGNA STAINLESS DIV. DE CSM INC.

525 MELOCHE AVE.

DORVAL, QUEBEC H9P 2W2

(514) 631-1211 FAX: (514) 631-0013

COMMANDE  
SALES ORDER

0165171

ENDU À /  
OLD TO:LIVRÉ À /  
SHIP TO:

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY  
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.					
0165171		DART		5788		613 632-5200		632-4443					
LIVRÉ VIA - SHIP VIA		CONDITIONS - TERMS		DATE COMMANDE DATE ORDERED		DATE REQUISE DATE REQUIRED		DATE LIVRÉE DATE DELIVERED					
NIR:R-557065-1		NET 30		Feb-25-08		Feb-29-08		15 26 EB					
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D				CONTRÔLE DE QUALITÉ DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D				PRÉPAYÉ PREPAID		À PERCEVOIR COLLECT			
QUALITÉ - QUALITY		UNITÉ UNIT		N° DE COULÉE HEAT NUMBER		DESCRIPTION		QTE LIVRÉE QTY SHIPPED		PRIX PAR PRICE PER		INSTRUCTIONS DE L'USINE PLANT INSTRUCTIONS	
COMMANDE ORDERED		A VENIR - B/O											
10		pcs		Bma13		6061-T6 8.25 X 7.95 X 2 1/2" GRAIN TO RUN ALONG 7.95		10		1.59		10 pcs CE 496 CE 499	
10		pcs		Bma13		8.25 X 6.5 X 2 1/2" GRAIN TO RUN ALONG 6.5 SPEC QQ-A-250/11		10		1.59		10 pcs CE 498 CE 499	
						TOTAL :						LBS	

NOMBRE DE PAQ.  
NUMBER OF BOL'SMTR-AVEC COMMANDE  
MTR'S-WITH ORDERPOSTE  
MAILTÉLÉCOPIEUR  
FAX

\*\*PACKING SLIP / BON D'EMBALLAGE\*\*

Page: 1

15:31:48

20080225

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ  
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISION 'R' - 07/07 - FORM 8009

S.C. ALPROM S.A.	CERTIFIED SRAC-IQNet	MILL	EN 10204	No.
SLATINA	ISO 9001/2001 No. 23/2-2005	CERTIFICATE	3.1	3044

CUSTOMER :

CONTRACT/ORDER : 12612-18344-3-01

BILL OF DELIVERY : 68715

TRUCK/CONTAINER : ZCSU 2376996

ALUMINUM PRODUCTS (PLATES).

12612-18344-3-01 SHIPMENT OF 40,643.738 LBS ALUMINUM PLATES 6061-T651, MILL FINISH.

ACCORDING TO ASTM B-209-04, AMS 4027M, AMS QQA 250/11F FROM CONSTANTA ROMANIA

TO BALTIMORE, MD. L/C NO. 1144856. CFR BALTIMORE, MD.

MATERIAL : ALUMINUM PLATES

ALLOY : 6061

TEMPER: T651

DIMENSIONS (mm) : BM113 - 1 2.5000"THX48.50"WDX144.50"LT  
BM176 - 1 4.0000"THX80.50"WDX144.50"LT

ACCORDING TO : ASTM B-209-04, AMS 4027 M, AMS-QQA 250/11F

MECHANICAL PROPERTIES			1 MPa = 1 N/mm2 = 0.145 ksi = 0.102 kgf/mm2							
1 lbs = 0.4536 kg			UTS		YTS	Elong. %	Hardness			
			ksi		ksi	50mm	HB			
			min.	max.	min.	max.	min.	min.		
Specified values:			42		35		8			
LOT / BATCH	CASE	NET WEIGHT lbs	Measured values:							
BM113 1	216;235;236;245;249	15,385.802	46.1	42.5	9					
BM113			46.7	42.3	9					
BM176 1	211;212;213	10,359.347	46.3	42.8	7					
6050580			44.5	40.6	9					
CHEMICAL PROPERTIES %										
BATCH	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ni	Ti	Al
BM113	0.46	0.47	0.17	0.14	0.97	0.06	0.18	0.007	0.02	REM.
6050580	0.56	0.4	0.19	0.09	1	0.08	0.054	0.003	0.016	REM.
Min.	0.4		0.15		0.8	0.04				REM.
Max.	0.8	0.7	0.4	0.15	1.2	0.35	0.25	0.05	0.15	
Cond.			Others Each: 0.05				Others Total: 0.10			

REMARKS:

We hereby certify that the material detailed hereon has been produced and tested according to the requirements of the relevant specification and/or order. Keep in dry conditions, without large temperatures variations.

Date: 6/5/2006 QUALITY CONTROL DEPT.

S.C. ALPROM S.A.  
SLATINA

S.C. ALPROM S.A.  
CERTIFICATE